

Work Order ID 128535

128535

Page 1

January-19-15 7:39:09 AM

Item ID: D4681-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Web Assembly
 Start Date: 1/19/15 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 1/30/15 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 15-01-19 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4681	B

110 0.00

110

Skidtubes Memo 0.00
 Skidtubes 1- CUT TO LENGHT AS PER DWG

4 0 15-1-19 Doc gju

120 QC6- Inspect dimensions to drawing 0.00

120

QC Memo 0.00
 Quality Control

4 0 15/02/10 only

January-19-15 7:39:09 AM

Item ID: D4681-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Web Assembly

Stop *NS2*

Start Date: 1/19/15 **Start Qty:** 4.00

4

Cust Item ID:

Required Date: 1/30/15 **Req'd Qty:** 4.00

4

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

121

0.00

121

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

MILL AS PER DWG AND FOLIO FB186

DWG REV: 13
FOLIO REV: A

DEBURR

122

QC2- Inspect parts off machine FAI/FAIB

0.00

1 22

OC

Memo

0.00

Quality Control

123

QC8- Inspect parts - second check

0.00

123

OC

Memo

0.00

Quality Control

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130	Chemical Conversion Coat per QSI005 4.1	0.00							
130	HandFinish	0.00							
Hand Finishing	Memo								

15-2-23 *[Signature]*

DAS
18
9-09

140	QC7-Inspect Chemical Conversion Coat	0.00							
140	QC	0.00							
Quality Control	Memo								

4 0 15-02-24

150		0.00							
150	Skidtubes	0.00							
Skidtubes	Memo								

4 15-4-6 *[Signature]*

INSTALL DOUBLER BY REVITING AND SEALING FAYING SURFACE
 WITH PROSEAL AS PER DWG
 A/R PROSEAL: M 130986
 exp: 15-6-30

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Item ID: D4681-041 Accept ***N900040100*** Setup Start ***NS1***
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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC5- Inspect part completeness to step on W/O	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: <u>L6002</u>	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

DAS
03
2-88

15-4-7

15-4-6

15-4-8

15-4-7

Picklist Print

January-19-15 7:39:09 AM

Page 1

Work Order ID: 128535

128535

Parent Item: D4681-041

D4681-041

Parent Item Name: Web Assembly

Start Date: 1/19/15

Required Date: 1/30/15

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 13.04.15 NEW ISSUE DD VERF:JLM
REV:B 13.08.08 PB1 DD VERF:JLM
13.11.14 AS PER DWG REV.B DD VERF:JLM

IPP
IPP REV:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2963-125

Manufactured No

Each 66.0000

4

D2963-125

105 I Beam Extrusion

**

15-1-19

Location

Loc Qty

Loc Code

HALL

66

115870

55

28673

11

Each

3.0000

4

D4681-3

Manufactured No

D4681-3

Doubler

**

15-4-6

Location

Loc Qty

Loc Code

LG002

3

128552

3

126879

Each

1,609.000

5

3

MS20470AD4-6

Purchased No

MS20470AD4-6

RIVET

**

15-4-6

Location

Loc Qty

Loc Code

CCK003

1488

m128754

1488

GA

112

131618

127383

112

ST310

9

m129499

9

359

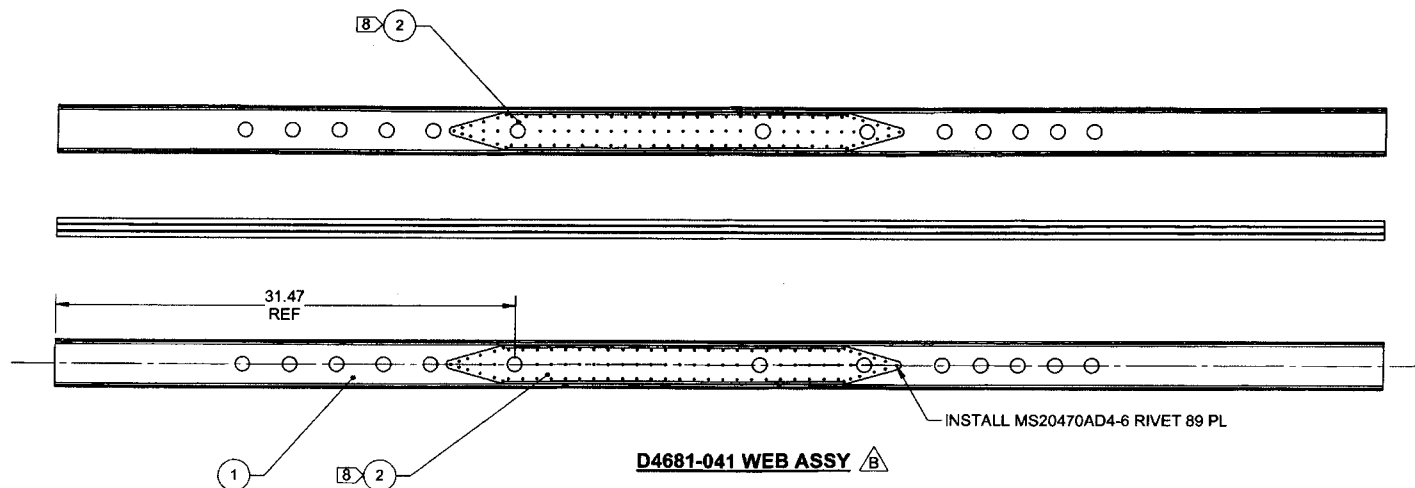
ITEM	QTY	P/N	DESCRIPTION
	X	D4681-041	WEB ASSY
1	1	D4681-1	WEB
2	2	D4681-3	DOUBLER
3	89	MS20470AD4-6	RIVET, PAN HEAD

△B

FOR COPY
TO
COPYING
COPY
FUNDAMENT
FORCE
DATE

128535 MLJ

1501-19



D4681-041 WEB ASSY △B

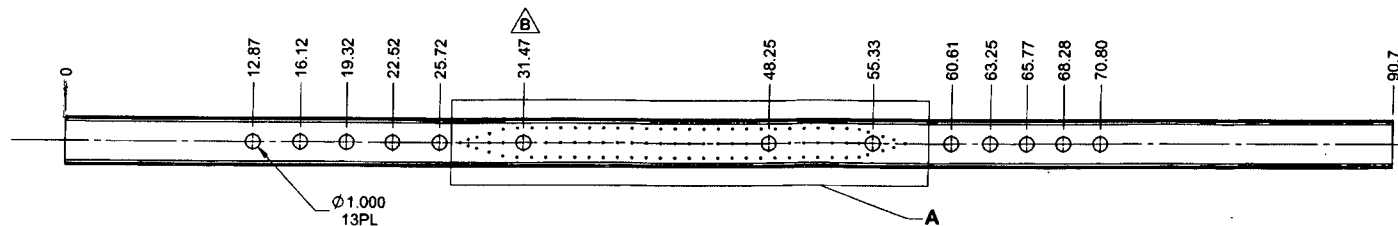
RELEASED
2013-11-13
WJ

NOTES:

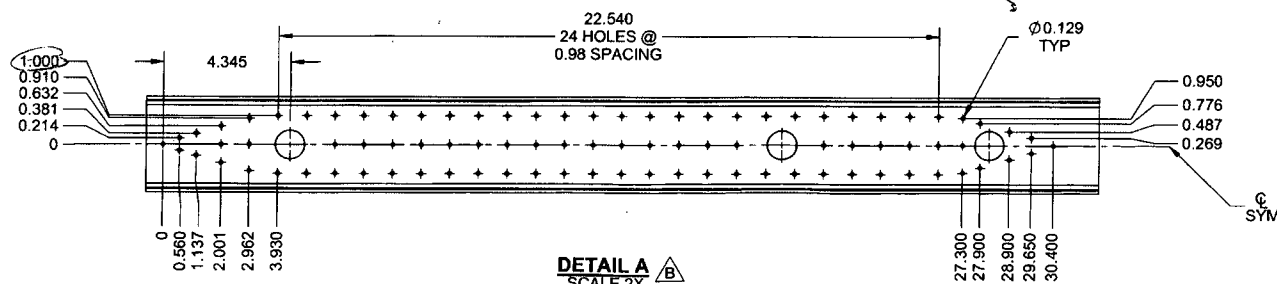
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4681-041" AND B/N PER QSI 044 METHOD 6.1
- 7) WEIGHT: 5.94 lbs
- 8) SEAL FAYING SURFACES WITH PROSEAL P/S 890 B-1/2 (PRC)

B	MS20470AD4-6 WAS MS20470AD4-7. ADDED DETAIL A ON SHEET 2. VARIOUS DIMENSIONAL CHANGES.	AP	13.08.08
A	NEW ISSUE	AP	13.02.13
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	AP		
CHECKED	ALS	DRAWING NO.	REV. B
MFG. APPR.	9/1	D4681	SHEET 1 OF 4
APPROVED	9/1	TITLE	SCALE
DE APPR.	9/1	WEB ASSY	NTS
DATE	13.08.08	COPYRIGHT © 2013 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

8 7 6 5 4 3 2 1



D4681-1 WEB



DETAIL A
SCALE 2X

- NOTES:**
- 1) MATERIAL: MAKE FROM D2963-092 EXTRUSION
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 4.74 lbs

DESIGN	AP	DART AEROSPACE USA, INC.	
DRAWN	AP	KENT, WA	
CHECKED	ASS	DRAWING NO	REV. F
MFG. APPR.	21	D4681	SHEET 2 OF 4
APPROVED	21	TITLE	SCALE
DE APPR.	21	WEB ASSY	NTS
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RELEASE
2013-11-13

8 7 6 5 4 3 2 1

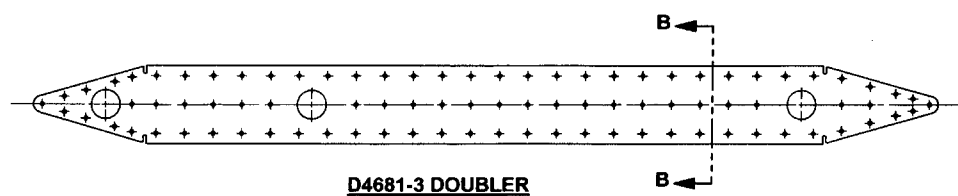
8 7 6 5 4 3 2 1

D

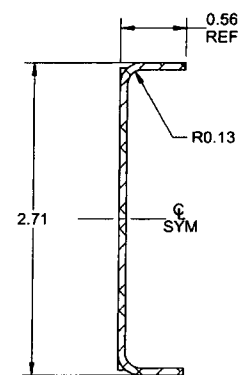
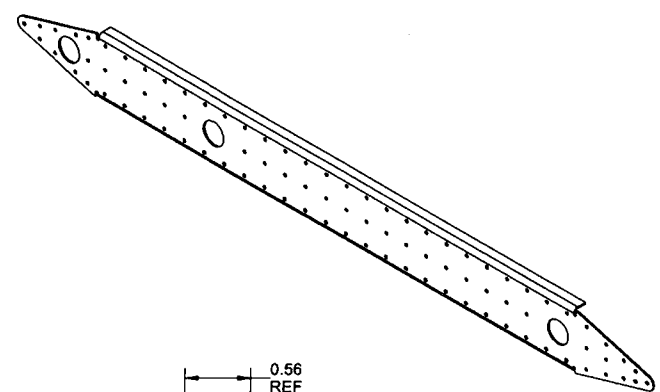
C

B

A



D4681-3 DOUBLER



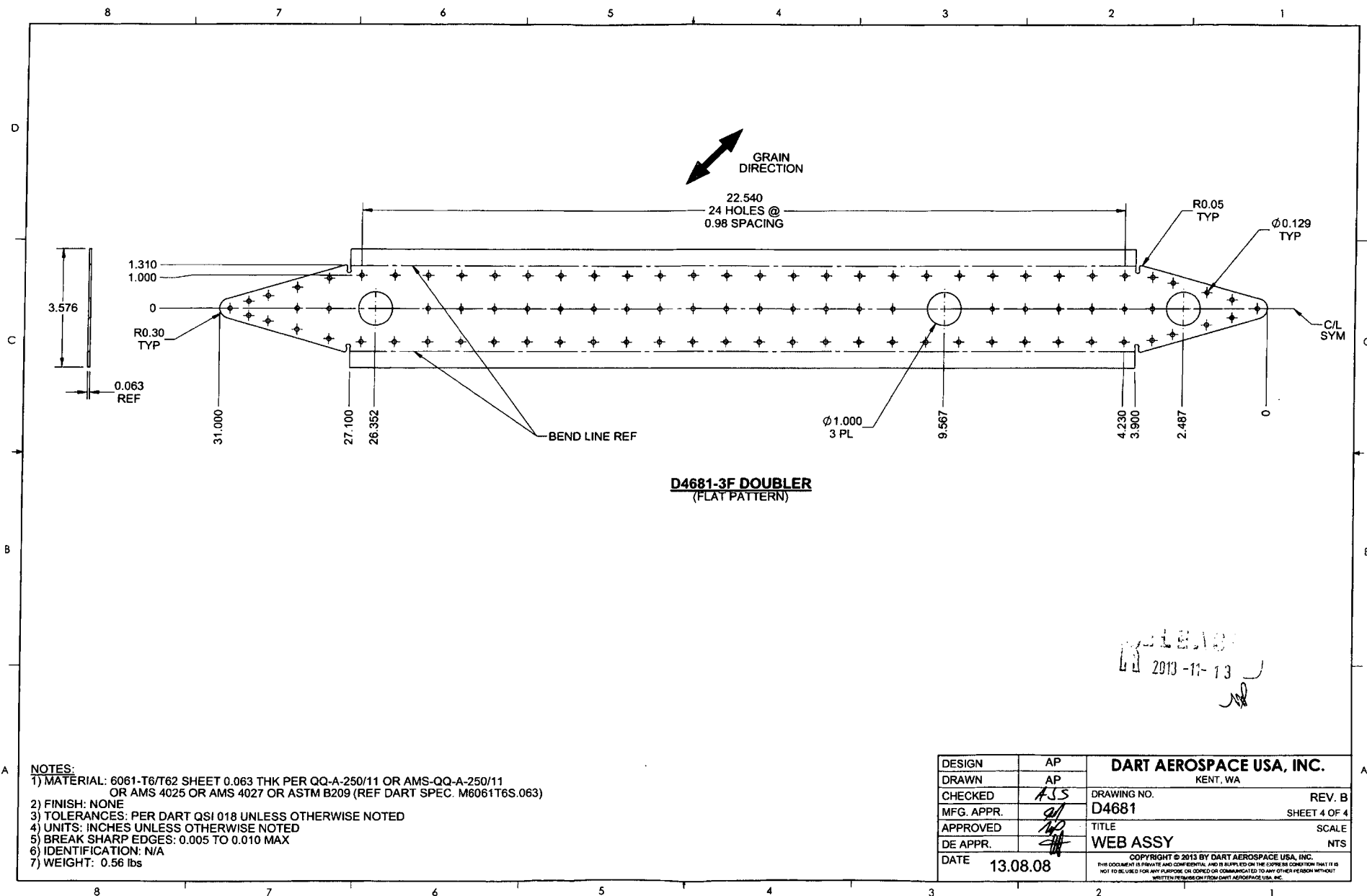
SECTION B-B
SCALE 4X

RELEASED
2013-11-13
[Signature]

- NOTES:**
- 1) MATERIAL: MAKE FROM D4681-3F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: .56 lbs

DESIGN	AP	DART AEROSPACE USA, INC.	
DRAWN	AP	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4681	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WEB ASSY	NTS
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8 7 6 5 4 3 2 1



DART AEROSPACE LTD		Work Order: 128535
Description: Web Assembly		Part Number: D4681-041
Inspection Dwg: D4681 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
90.7	+/- .100	90.70	✓		Tape	Fk-05
12.87	+/- .030	12.87	✓		"	"
16.12	+/- .030	16.12	✓		"	"
19.32	+/- .030	19.32	✓		"	"
22.52	+/- .030	22.52	✓		"	"
25.72	+/- .030	25.72	✓		"	"
31.47	+/- .030	31.47	✓		"	"
48.25	+/- .030	48.25	✓		"	"
55.33	+/- .030	55.33	✓		"	"
60.61	+/- .030	60.61	✓		"	"
63.25	+/- .030	63.25	✓		"	"
65.77	+/- .030	65.77	✓		"	"
68.28	+/- .030	68.28	✓		"	"
70.80	+/- .030	70.80	✓		"	"
Ø 1.000	+ .010 / - .001	1.001	✓		Vern	Fk-04
Ø .129	+ .005 / - .001	.1285	✓		"	"
1.000	+/- .010	1.000	✓		"	"
4.345	+/- .010	4.344	✓		"	"
22.540	+/- .010	22.540	✓		Tape	Fk-05
.98	+/- .030	.98	✓		Vern	Fk-04

DAS

44

9-89

Measured by:		Audited by:	<i>[Signature]</i>	Preliminary Approval:	
Date:	15/02/10	Date:	15/02/10	Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

[Signature] 10.04.15